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D3438-042
Job Sheet 193059



Part No: D3438-042

Job Qty: 1 pcs

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 4/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	4/22/19		0.00	1.28	Large Fab - 1		SLU
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	1 pcs	4/22/19		0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	4/22/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

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				QC 5 - 30	
				QC 5 - 40	
130 Handfinish - 1-1 Chemical- B4B	1 pcs	4/22/19	0.00 0.49	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR19/04/25
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 QC 3	1 pcs	4/22/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	APR 25 2019 68
				QC 3 - 9	
				QC 3 - 40	9-89
				QC 3 - 19	
150 Large Fab - Welded Assy-2-B4B	1 pcs	4/22/19	0.00 1.28	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SLC
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	

					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
160 QC 10	1 pcs	4/22/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
170 QC 5	1 pcs	4/22/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
175 Handfinish - 6-1- Touch Up- B4B	1 pcs	4/22/19	0.00 0.10		Handfinish - 6 - 1 - B4B	
					Handfinish - 6 - 2 - B4B	
					Handfinish - 6 - 3 - B4B	
					Handfinish - 6 - 4 - B4B	
					Handfinish - 6 - 5 - B4B	
					Handfinish - 6 - 6 - B4B	
					Handfinish - 6 - 7 - B4B	
					Handfinish - 6 - 8 - B4B	
					Handfinish - 6 - 9 - B4B	
					Handfinish - 6 - 10 - B4B	
					Handfinish - 6 - 11 - B4B	
					Handfinish - 6 - 12 - B4B	
					Handfinish - 6 - 13 - B4B	
					Handfinish - 6 - 14 - B4B	
					Handfinish - 6 - 15 - B4B	
					Handfinish - 6 - 16 - B4B	
					Handfinish - 6 - 17 - B4B	
					Handfinish - 6 - 18 - B4B	
					Handfinish - 6 - 19 - B4B	
					Handfinish - 6 - 20 - B4B	
					Handfinish - 6 - 21 -	

				B4B	
				Handfinish - 6 - 22 - B4B	
180 Powdercoat - 1 White GI(A)- B4B	1 pcs	4/22/19	0.00 0.14	Powdercoat - 1 - B4B	
START: 10:15 / QTY: 320° FINISH: 10:45				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-4-26
				Powdercoat - 4 - B4B	
				Handfinish - 3 - 1 - B4B	11 19-4-25
190 Handfinish - 3-1- WingWalk- B4B	1 pcs	4/22/19	0.00 0.49	Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
200 QC 3	1 pcs	4/22/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	11 19-4-25
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	11 19-04-30
				QC 3 - 40	
				QC 3 - 19	
210 Packaging 3-1 - Stock - B4B	1 pcs	4/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

DAS
15
9-89

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	DAG 21
				Packaging 3 - 35 - B4B	9-30 APR 30 2019
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	1 pcs	4/22/19	0.00 0.00	QC 21 - SA - 21	DAG 21
				QC 21 - SA - 70	9-30 APR 30 2019
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap,
 Descriptions: LUG PLATES & MOUNTING ANGLE as per Dwg D3438 using DT8343 4-Grind
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC3- Inspect Part Finish)
 150 - (Weld per dwg A/R Aluminum rod Batch: _____) Weld last cap per dwg D3438 & grind flush
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 175 - Touch up alodine
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 1-Touch up alodine
 190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	3081118
D2561	Lug	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5160076
D2673-34	End Plate	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5161432
D2564	Mounting Angle	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5165433

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	1	75	0
	D2561	2	24	0
	D2564	2	47	0
	D2673-34	2	38	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042) _____	
Description Work Order Deviation		Disposition		
FAULT CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Completed By Lead hand / Supervisor QC / QA Coordinator		

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Container No: S175019



Part: D3438 - 042

Job No: 193059

Serial No/Batch: S175019

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/24/19